

Date: Tuesday, 4/18/2006 10:00:54 AM
 User: Kim Johnston

Process Sheet

19

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BEARPAW KIT (19"X24")
 Job Number : 26661
 Estimate Number : 10323
 P.O. Number : N/A Part Number : K10008
 This Issue : 4/18/2006 S.O. No. : N/A Drawing Number : D2432 REV F3
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : F3
 Previous Run : 26076 Material : N/A
 Due Date : 5/12/2006 Qty: ~~10~~ Um: Each
 Written By : SEE COMMENT BELOW
 Checked & Approved By : KJ 06.04.18
 Comment : Est Rev:J 04.02.17 Blank size changed KJJ/LM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile:
 K10008
 D206-559-013
 D350-578-011
 D427-659-011
 D315-670-011
 and create labels per PPP K10008
 CHG006(Bag Bluefiles separately)

KS 06.05.01

10.

2.0 MUHMWB10 UHMW 1" Black



Comment: Qty.: 6.8250 sf(s)/Unit Total : 68.2500 sf(s)
 blank: 19.500" x 24.00" x 1.00" thick (+0.030/-0.000) per DSK086-5
 Material: Black UHMW 1"
 (MUHMWB10)
 Batch: 19 100 501

KS 06.06.16

10

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Note:(2) bearpaws for (1) Kit

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio and Dwg D2432 Identify as D2432F

3-Deburr

J.F. 06/06/18

10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Part Number: K10008

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 06/06/18 10

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SG 06.06.18 10

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

7.0

D2182B

Neoprene Cushion-.750 bl



Comment: Qty.: 0.4200 f(s)/Unit Total : 4.2000 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 D2182B050 Rubber Cushion B24E70

8.0

D2274

Radius Block



Comment: Qty.: 12.0000 Each(s)/Unit Total : 120.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 D2274 Radius Block B26078

2 D2432F(ref only) Bearpaw B26661

9.0

D2438

Clamp



Comment: Qty.: 6.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 D2438 Clamp B25611

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Part Number: K10008

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

D2529

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 120.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 D2529

Washer

B26485

11.0

D2732

Rubber Extrusion



Comment: Qty.: 0.4166 f(s)/Unit Total : 4.1660 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 D2732-050

Rubber Cushion

B26472

12.0

AN415A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total : 120.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 AN4-15A

Bolt

M19085

13.0

AN417A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total : 120.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 AN4-17A

Bolt

M19471 ~~B26471~~

14.0

AN960JD416

Washer



Comment: Qty.: 24.0000 Each(s)/Unit Total : 240.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

24 AN960JD416

Washer

M100575

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/06/19

QA: N/C Closed: _____ Date: _____

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Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

MS21042L4

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total: 120.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 MS21042L4 Nut (or -4)

M19085

4/6/19 (10)

16.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

C206/19/06 (10)

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPPK10008

Location:

E

C206/19/06 (10)

18.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

D206/06/19 (10)

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	26661
Description: Bearpaw		Part Number:	D2432
Inspection Dwg: D2432 Rev: F3		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	0.058x45°	—			
B	5.500	+/-0.030	5.500	—			
C	0.200	+/-0.030	0.209	—			
D	0.25 x 45°	+/-0.030	0.235x45°	—			
E	R0.250	+/-0.030	R0.250	—			
F	0.250	+/-0.010	0.245	—			
G	0.625	+/-0.030	0.610	—			
H	0.375	+/-0.010	0.380	—			
I	0.950	+0.030/0.010	0.955	—			
J	19.000	+/-0.030	19.000	—			
K	3.14	+/-0.030	3.140	—			
L	3.28	+/-0.030	3.305	—			
M	Ø0.260	+0.005/-0.000	Ø0.260	—			
N	Ø0.93	+/-0.030	Ø0.928	—			
O	0.30	+0.030/-0.000	0.320	—			
P	23.750	+/-0.030	23.750	—			
Q	7.375	+/-0.030	7.375	—			
R	4.250	+/-0.010	4.250	—			
S	2.000	+/-0.030	2.015	—			
T	9.000	+/-0.010	9.000	—			
U	9.000	+/-0.010	9.000	—			
V	0.375	+/-0.010	0.380	—			

Measured by:	<i>JML</i>	Audited by:	J.L.	Prototype Approval:	N/A
Date:	06/06/16	Date:	06/06/16	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue P/O K10008/D206-559-015	KJ/RF <i>[Signature]</i>	<i>[Signature]</i>

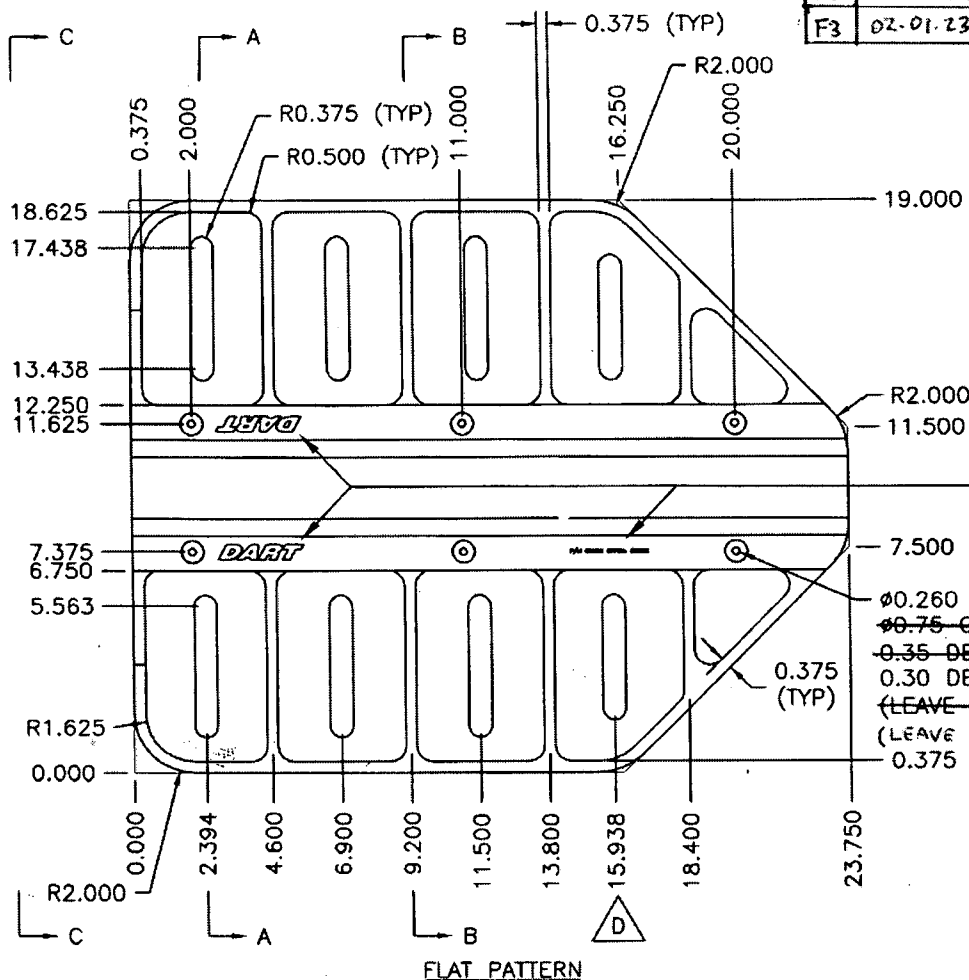


DESIGN	DRAWN BY	DART AEROSPACE LTD
KE	KE	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
MM	DA	D2432
DATE	TITLE	REV. F
98.05.12	BEARPAW	SHEET 1 OF 2
		SCALE
		1:6

RELEASED
98.06.17 KE

A	95.10.31	NEW ISSUE
B	96.01.24	RE-DESIGN
C	96.03.26	CHANGE BORE AND C'BORE DEPTH
D	96.06.04	MOVE SLOT
E	97.02.27	CHANGE C'BORE DEPTH, BORE RADIUS
F	98.05.12	CHANGE C'BORE, ADD B AND F P/N

F1	99.03.03	ADD DEO 9143
F2	01.03.28	Ø0.93 WAS Ø0.75 RF
F3	02.01.23	CLARIFY BORE DIMS RF



ENGRAVE LOGO TO MAX DEPTH OF 0.012. ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010. (TYPICAL LOCATION AS ILLUSTRATED)

FE
FI
F
FI

EFFECTIVE DEOS
9143

D2432F: FLAT BEARPAW
D2432B: BENT BEARPAW

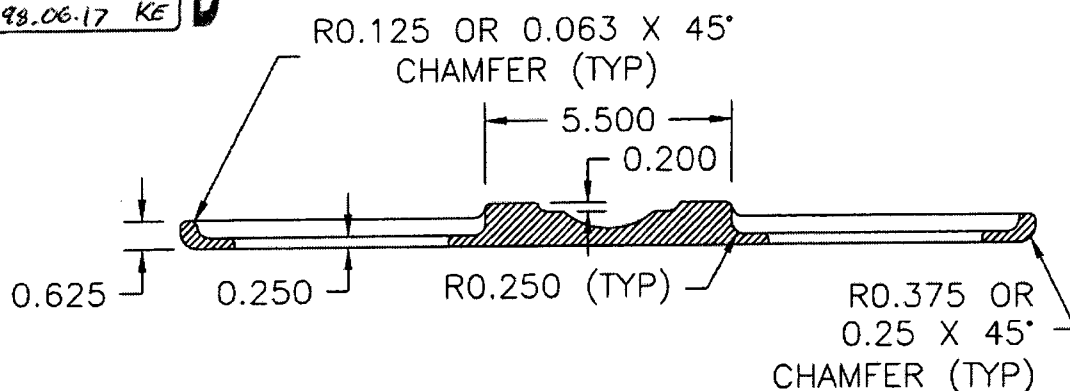
MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)

INCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
SHOP COPY
RETURN TO
ENGINEERING
COPY

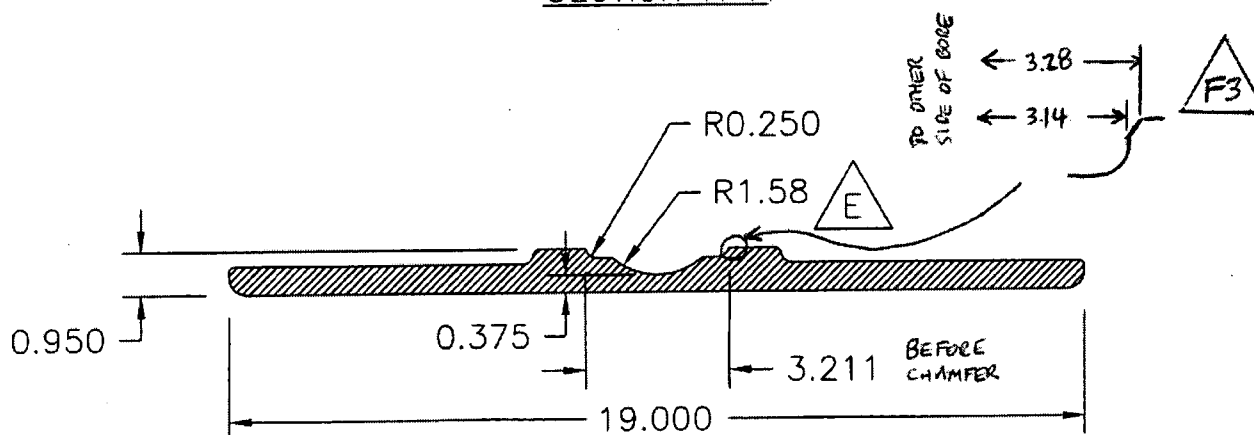


DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2432	REV. F SHEET 2 OF 2
DATE 98.05.12	TITLE BEARPAW		SCALE 1:4

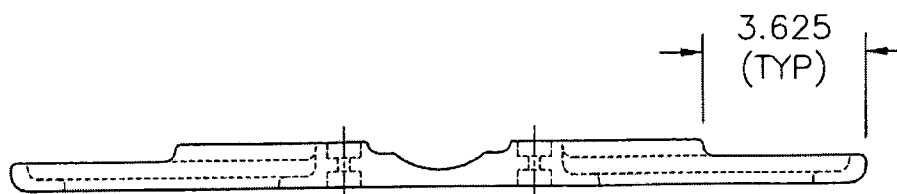
RELEASED
98.06.17 KE



SECTION A-A



SECTION B-B



SECTION C-C